

Date: Thursday, 12/14/2006 3:46:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 29977	Part Number	: D2739
Estimate Number	: 10498	Drawing Number	: D2739 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/14/2006 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 12/21/2006 Qty: 4 Um: Each
Previous Run	: 29867		
Written By	: <u>W</u>		
Checked & Approved By	: <u>DK</u> 06-12-15		
Comment	: Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin		
Pick: 1 Qty Part Number Description Batch 1 D2600-5 Web 244-10 JB 06-12-19 (4)		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739.  2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739  3-Use uni-bit to open holes to finish size as per Dwg D2739.  4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.  5-Dburr		
3.0	QC5	INSPECT WORK TO CURRENT STEP
 DP 06-12-19 (4)		
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:  
User:

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 29977

Part Number: D2739

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



JP / SP

6-12-22



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock  
Location: LG

DP / SP

6-12-22

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/14/06

Job Completion



12/14/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

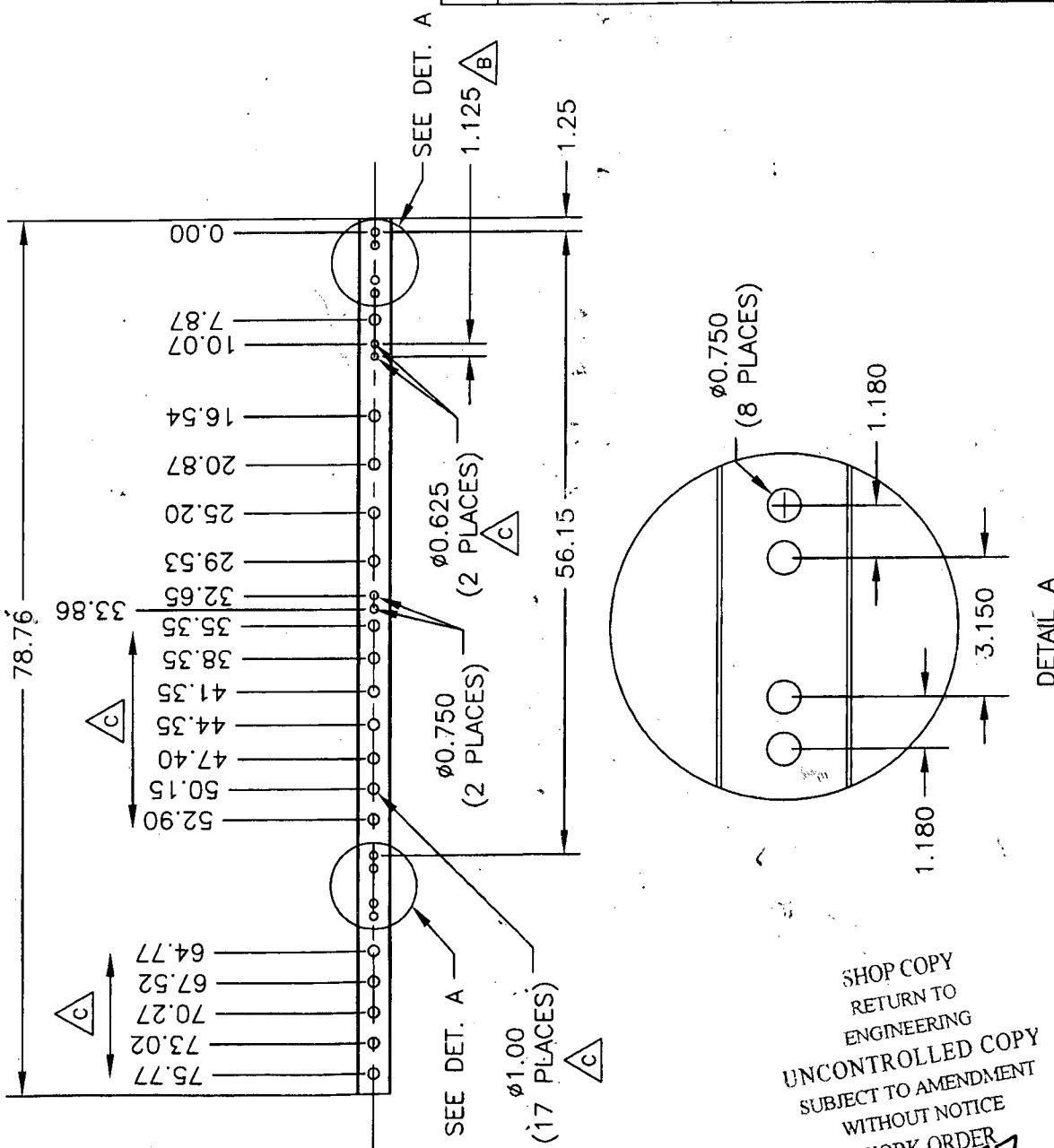
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## **DART**

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV. C SHEET 1 OF 1
DATE 06.01.05		TITLE WEB	SCALE 1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEÁSED  
ab. 02-57



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29977

D2739 WEB  
1) MATERIAL: MAKE FROM D2600-5 EXTRUSION  
2) FINISH: ACID ETCH, ALODINE PER DART QSI '005 4.1  
3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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